

Work Order ID 100125

April-18-13 10:25:24 AM

100125

350

Page 1

Item ID: 646.3301

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Upper Cutter Assembly

Start Date: 4/18/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/02/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 13-04-18 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

646.3300

N/C

110

Pick Kit

0.00

110

Packaging

Memo

0.00

10

ML/13-11-05

Packaging

120

0.00

120

Small Fab

Memo

0.00

10

ML/13-11-05

Small Fab

Two fastener must be install finger-tight (see note 9)

Assemble as per dwg and apply loctite 598 on all mating surfaces shown on dwg per note 7.

A/R LOCTITE 598: 125306

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Work Order ID 100125

April-18-13 10:25:24 AM

100125

Page 2

Item ID: 646.3301

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Upper Cutter Assembly

Start Date: 4/18/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/02/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

130

QC

Memo

0.00

Quality Control

10 13/11/11

140	Identify as per dwg & Stock Location	0.00							
-----	--------------------------------------	------	--	--	--	--	--	--	--

140

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV

10 13/11/11 DAS 6 9-89

150	QC21- Final Inspection - Work Order Release	0.00							
-----	---	------	--	--	--	--	--	--	--

150

QC

Memo

0.00

Quality Control

10 13/11/14 MF 13/11/11

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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QA Closed: _____ Date: _____

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Equip/Tooling									
Operator									
Material									
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FAULT CATEGORY

Landing Gear	General	Other
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		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Picklist Print

April-18-13 10:25:28 AM

Page 1 / 4

Work Order ID: 100125

Parent Item: 646.3301

Parent Item Name: Upper Cutter Assembly

100125

646.3301

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.3310 *646.3310* LH Half		Manufactured	No			110	Each	0.0000	1	10	**	B#103644 ^{X5} B#101088 m/m 13.11.05	
646.3311 *646.3311* RH Half		Manufactured	No			110	Each	0.0000	1	10	**	B#106057 ^{X5} B#100844 m/m 13.11.05	
646.3312 *646.3312* Center Plate		Manufactured	No			110	Each	0.0000	1	10	**	B#103083 m/m 13.11.05	
646.3313 *646.3313* Upper Guide		Manufactured	No			110	Each	0.0000	1	10	**	B#102884 m/m 13.11.05	
646.3314 *646.3314* Blade		Manufactured	No			110	Each	0.0000	1	10	**	B#103049 m/m 13.11.05	
646.3315 *646.3315* Blade		Manufactured	No			110	Each	0.0000	1	10	**	B#103034 m/m 13.11.05	
646.3316 *646.3316* Blade		Manufactured	No			110	Each	0.0000	1	10	**	B#102893 ^{X6} B#103515 m/m 13.11.05	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
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		<input type="checkbox"/> Weld
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Picklist Print

April-18-13 10:25:28 AM

Page 2

Work Order ID: 100125

Parent Item: 646.3301

Parent Item Name: Upper Cutter Assembly

100125

646.3301

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 10.00

Required Qty: 10.00

NAS1149FN832P

Purchased

No

110

Each

17,683.00

36

360

NAS1149FN832P

Washer

**

Location

Loc Qty

Loc Code

ST294

7683

115158

3

123522

400

123900

7280

ST510a

10000

125268

10000

123900

whl 13.11.05

MS21042L08

Purchased

No

110

Each

3,204.000

18

180

MS21042L08

Nut

**

Location

Loc Qty

Loc Code

ST315

3204

122141

3

122452

9

122814

500

123900

2692

122814

whl 13.11.05

NAS1149F0332P

Purchased

No

110

Each

8,690.000

6

60

NAS1149F0332P

WASHER

**

Location

Loc Qty

Loc Code

GA

182

122063

182

ST294

158

122063

158

ST295

3

123352

3

st510

8347

123900

8347

123900

April-18-13 10:25:28 AM

Shop Packet Print

Page 2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
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FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
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Page 3

Work Order ID: 100125

Parent Item: 646.3301

Parent Item Name: Upper Cutter Assembly

100125

646.3301

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 10.00

Required Qty: 10.00

AN3-12A

Purchased

No

110

Each

59.0000

2

20

AN3-12A

Bolt

**

13-11-05

Location

Loc Qty

Loc Code

GA

6

126192

122407

6

ST351

5

114536

1

123352

4

ST512

48

123759

48

MS21042L3

Purchased

No

110

Each

4,758.000

3

30

MS21042L3

Nut

**

13-11-05

Location

Loc Qty

Loc Code

FP001

3

126333

122141

3

GA

115

122452

115

ST314

268

117885

32

119017

55

119075

138

123265

43

ST506

4372

123900

974

124291

3398

April-18-13 10:25:28 AM

Shop Packet Print

Page 3

NCR: Yes / No

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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Picklist Print

April-18-13 10:25:28 AM

Page 4

Work Order ID: 100125

Parent Item: 646.3301

Parent Item Name: Upper Cutter Assembly

100125

646.3301

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 10.00

Required Qty: 10.00

MS27039-08-19

Purchased

No

110

Each

1,702.000

18

180

MS27039-08-19

Screw

**

ml 13.11.05

Location

Loc Qty

Loc Code

ST307

102

125654

123352

2

123525

100

st510

1200

124309

1000

124859

200

ST517

400

124579

400

AN3-14A

Purchased

No

110

Each

87.0000

1

10

AN3-14A

Bolt

**

ml 13.11.05

Location

Loc Qty

Loc Code

ST512

87

126192

123759

87

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
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<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 03724

SHEET 1 OF 1

DWG NO. 646.3300

REV: N/C

PREPARED
BY B. PETERS

DATE: 12/05/12

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: UPPER CUTTER ASSY

APPROVED BY:

ENGR

MFG

QC

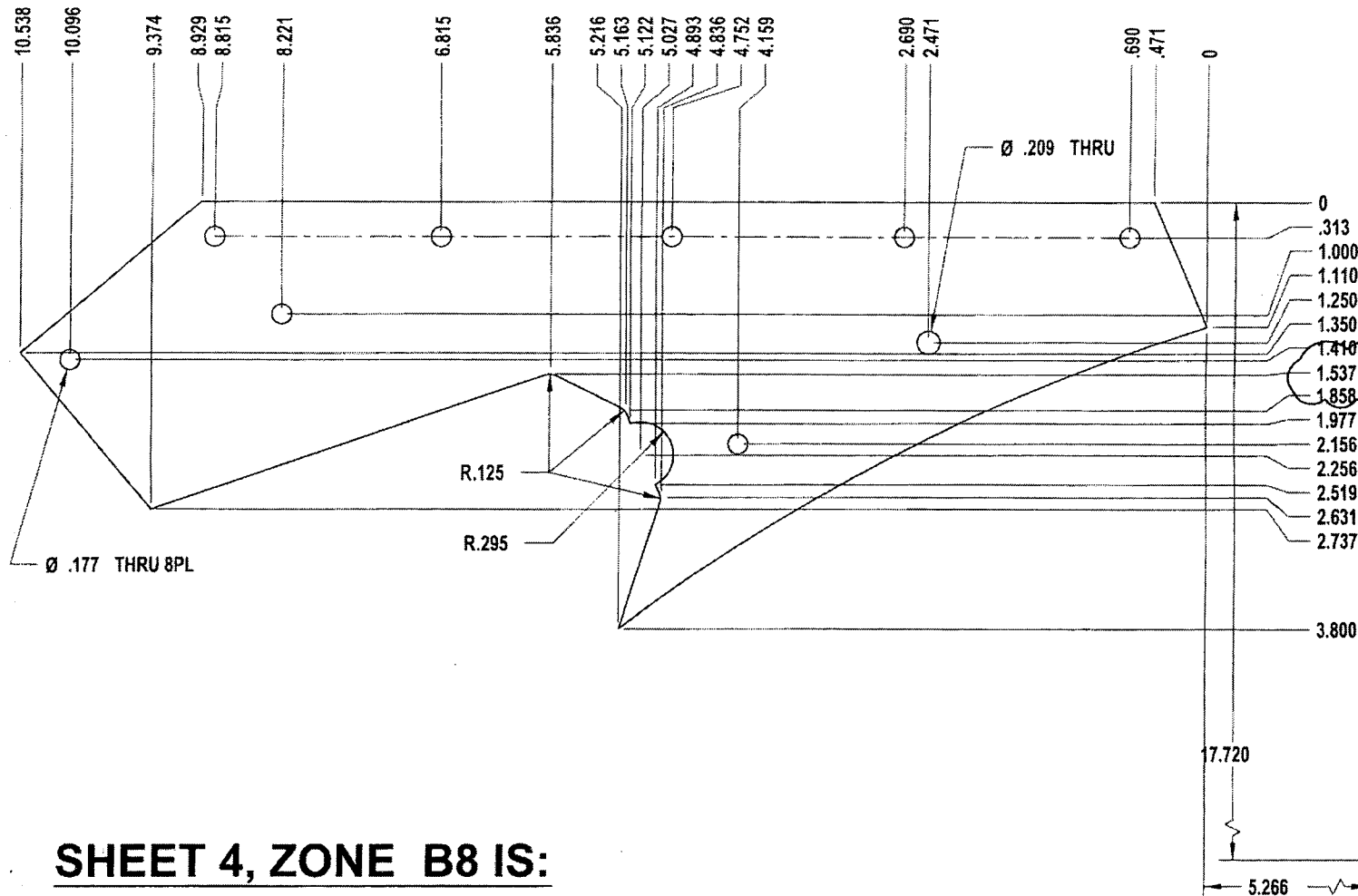
EFF: NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON:

REVISED ORDINATE DIMENSION.

ECR:
D-12-025



SHEET 4, ZONE B8 IS:

DOCUMENTS EFFECTED:

☐ RFMS ☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ BOM

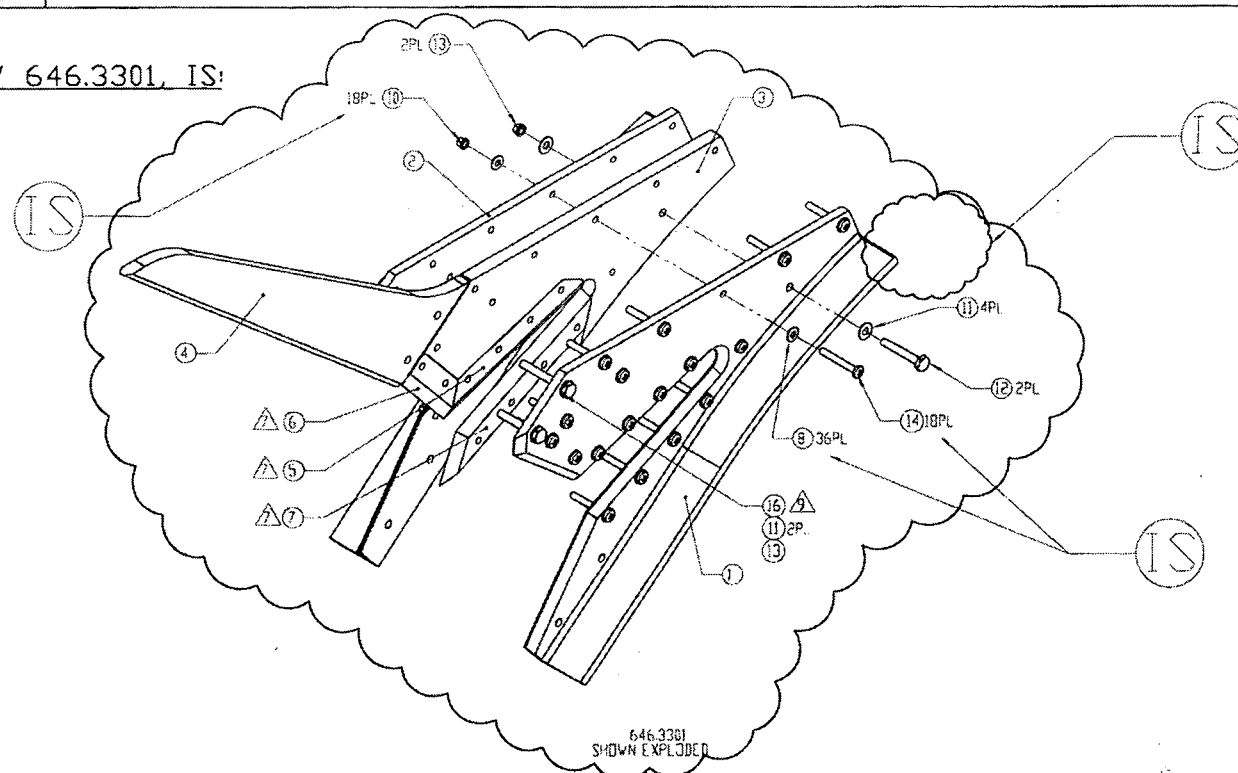
CHANGE CATEGORY
☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED
☐ YES ☒ NO

100125

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICL NO. 02196		SHEET 1 OF 2	
	DWG NO. 646.3300	REV: N/C	PREPARED BY S. HUFF	DATE: 01/05/09
	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.			
DWG TITLE: UPPER CUTTER ASSY				
APPROVED BY: ENGR <i>[Signature]</i>	MFG: <i>[Signature]</i>	QC: <i>[Signature]</i>	EFF: NEXT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REMOVED RIVETS IN FAVOR OF ADDITIONAL SCREWS			

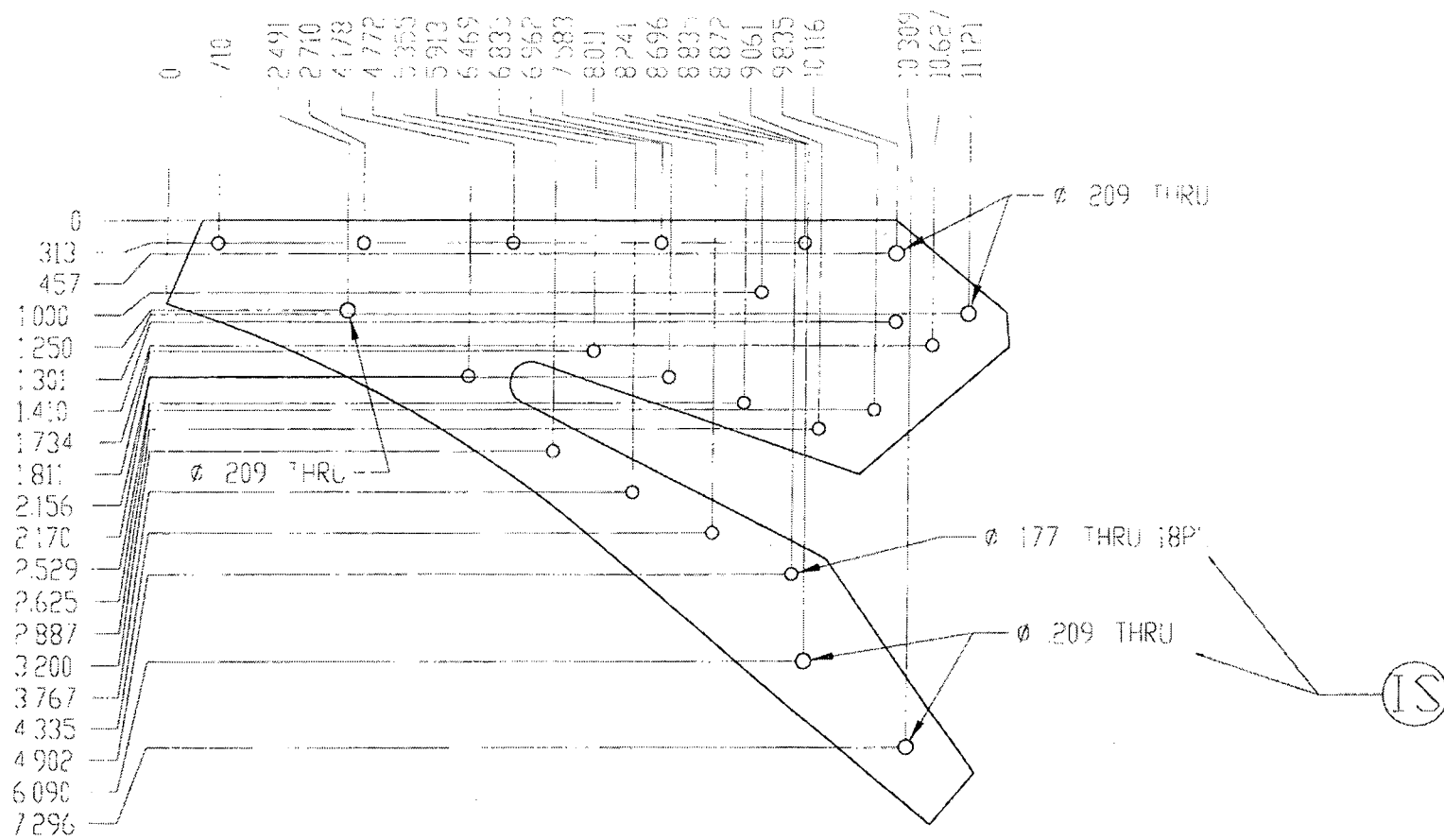
SHEET 1, VIEW 646.3301, IS:

646.3301
SHOWN EXPLODED

14	R	601.2765	18	SCREW	MS27039-0819
10	R	601.1541	18	LOCKNUT	MS21042L08
9	D	601.2766	.3	RIVET	MS20470AD5-18
8	R	601.2764	36	WASHER	NAS1149FN832P
			3301		
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:				<input type="checkbox"/> MDL <input checked="" type="checkbox"/> INSTALL INSTRUC <input checked="" type="checkbox"/> ICA <input type="checkbox"/> FMS <input checked="" type="checkbox"/> BOM	CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR
					DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

100125

SHEET 3, SECTION VIEW A-A, IS:



SECTION A-A

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

16
15
14
13
12
11
10
9
8
7
6
5
4
3
2
1

16PL 13
15PL 10
3
9 3PL
11 4PL
12 2PL
14 15PL
8 30PL
16 9
11 2PL
13
1

ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
ANODIZE IAW MIL-A-8625 TYPE III
COLOR BLACK;
4860-50 PRETREATMENT PRIMER
MIL-P-23377J TYPE I CLASS N
AISI A2 TOOL STEEL
ANNEALED

1	16	601
15	15	601
14	14	601
13	13	601
12	12	601
11	11	601
10	10	601
9	9	601
8	8	601
7	7	646
6	6	646
5	5	646
4	4	646
3	3	646

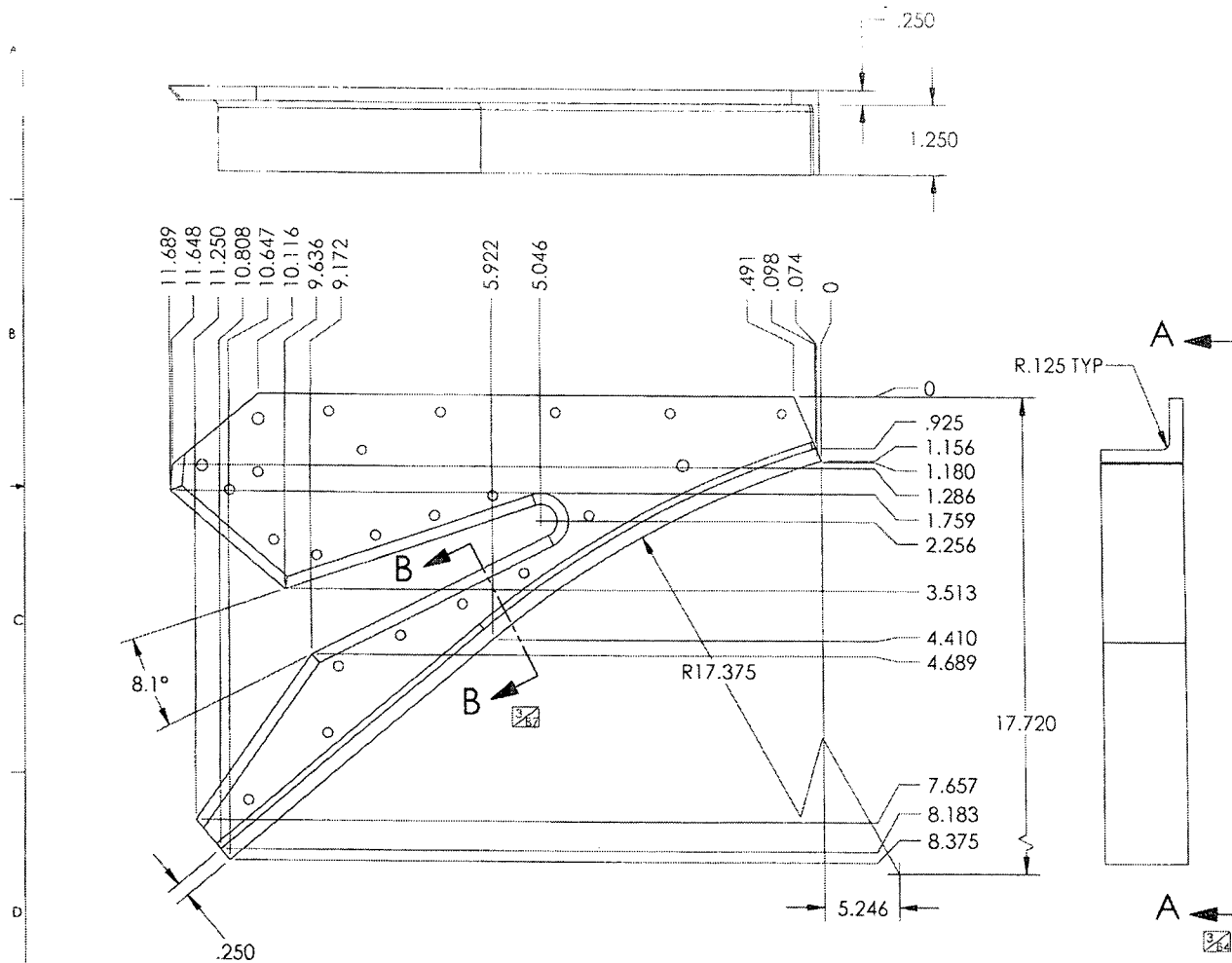
02196, 03724

- ① MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- ② FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
- ③ MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- ④ FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N
5. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
6. IDENTIFY IAW MPP-120
- ⑦ APPLY F/N 15 AS REQUIRED TO ALL FAYING SURFACES OF F/N 5, 6 & 7 UPON ASSEMBLY
- ⑧ CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE
- ⑨ INSTALL FASTENER FINGER-TIGHT

646.3301
SHOWN EXPLODED

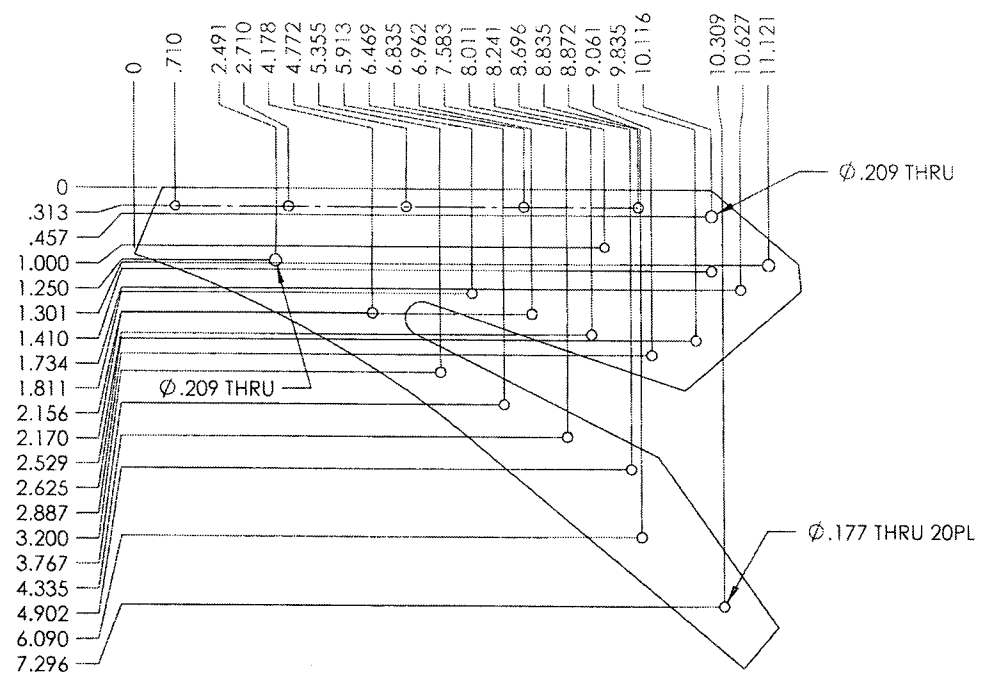
[illegible]

100125

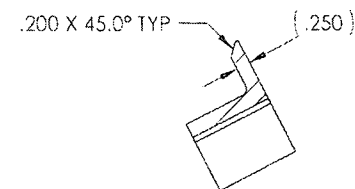


646.3310 SHOWN
646.3311 OPPOSITE

ORIGINAL DATE: 02-20-08		APICAL INDUSTRIES	
DESIGNER: J. B. BROWN		2609 TEMPLE HEIGHTS DR.	
DRAWN: J. B. BROWN		OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED: J. B. BROWN		UPPER CUTTER ASSY	
DATE: 02-20-08		646.3300	
SCALE: NONE		SHEET 2 OF 8	

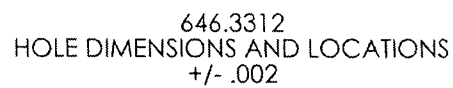


SECTION A-A



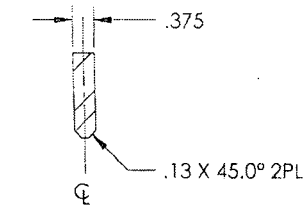
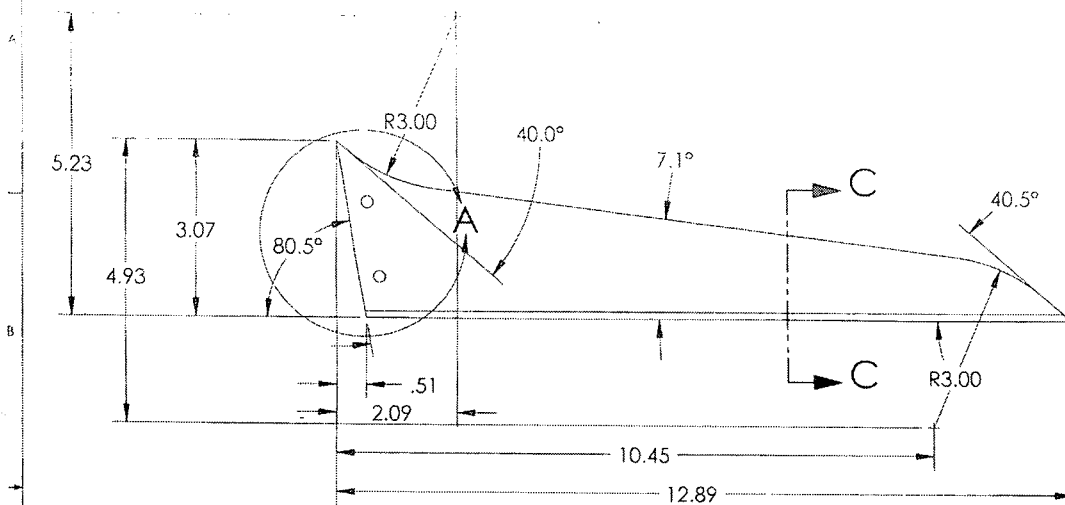
SECTION B-B

ORIGINAL DATE (INCHES) 08-20-08 DRAWN BY E. HUNT DRAWING APPROVAL (SIGNATURE)	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DECIMALS ARE 2 PLACE DECIMALS 3 PLACE DECIMALS 5000 ANGLES 1°	UPPER CUTTER ASSY SEE: CHANGE CODE B: 07/02/16 SCALE: NONE SHEET 3 OF 6
PART NO. 646.3300 REV. NTC	

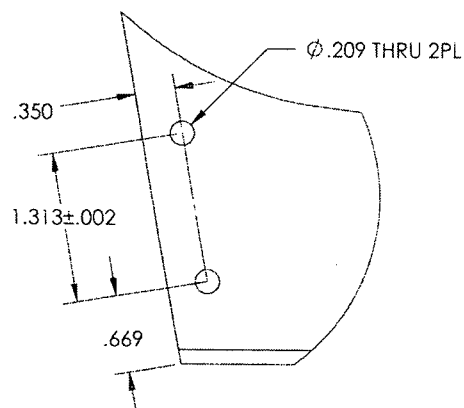
[illegible]

ORIGINAL DATE (M/C-DAY-YR) 05-26-08 DRAWING BY J. HUNT DRAWING APPROVAL R. BRAVO 05-26-08 (CUT) BACK: NS	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300			
UPPER CUTTER ASSY				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES 1. PLACE DECIMALS 1.00 2. PLACE DECIMALS 1.00 3. PLACE DECIMALS 1.00	QTY 1 SCALE: NONE	CAGE CODE 079626 DWG NO 646.3300	REV N/C	SHEET 4 OF 8

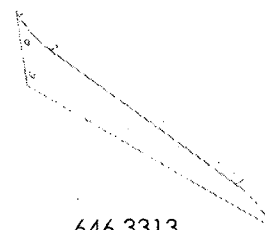
100125



SECTION C-C

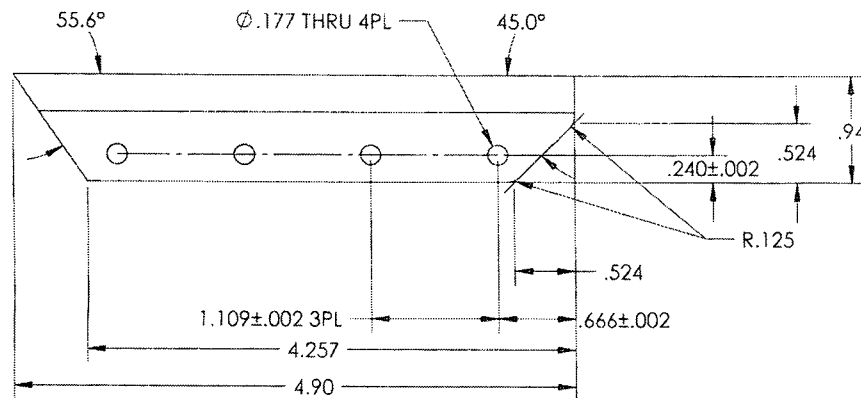


DETAIL A

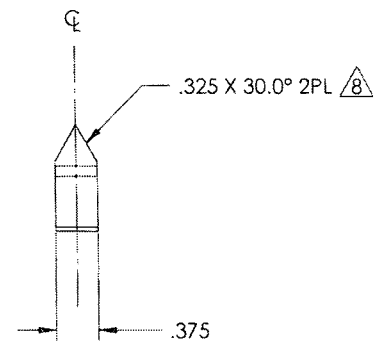
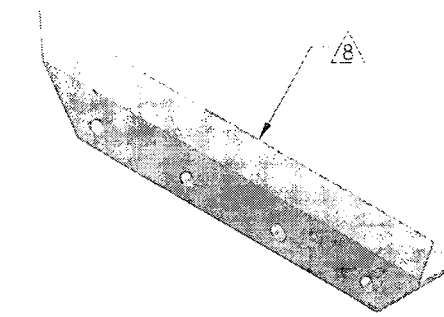


646.3313

ORIGINAL DATE 10-24-11 08:28:05 DRAWN BY: J. KUIP 1. KUIP P. BRAND DRAWING APPROVAL: P. BRAND 05/26/12 05/26/12		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300	
1. PARTS OTHERWISE SPECIFIED 2. DIMENSIONS ARE IN INCHES 3. TOLERANCES ARE: 4. PLATE DECIMALS ±.01 5. PLATE DECIMALS ±.005 6. HOLE ±.01		MFG. DATE CODE B 07/14/16	DWG. NO. 646.3300
SCALE: NONE		SHEET 5 OF 8	



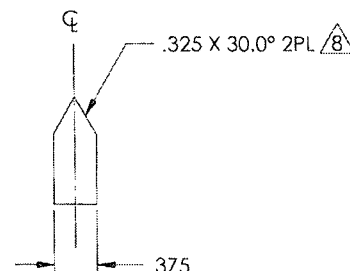
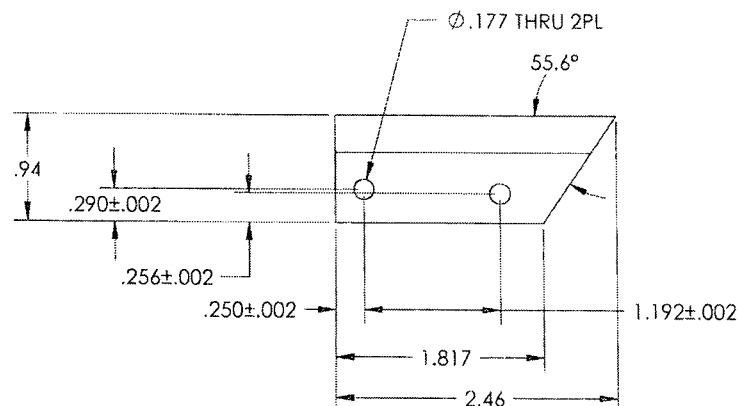
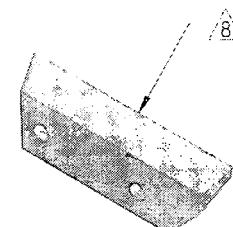
646.3314



ORIGINAL DATE REV. 10-10-01		DESIGNED BY J. M. H. / J. M. H.	
DRAWN BY J. M. H. / J. M. H.		CHECKED BY J. M. H. / J. M. H.	
APPROVED BY J. M. H. / J. M. H.		DATE 10-10-01	
PROJECT NO. 646.3300		SCALE NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE FRACTIONS DECIMALS ±.01 ANGLES ±.5		REV. 10-10-01 646.3300	REV. 10-10-01 646.3300
SHEET 6 OF 6		SHEET 6 OF 6	

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA 92056-3512 (760)724-5300

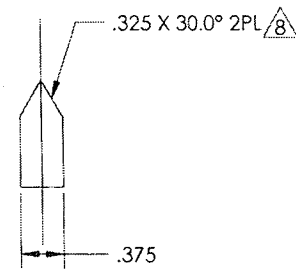
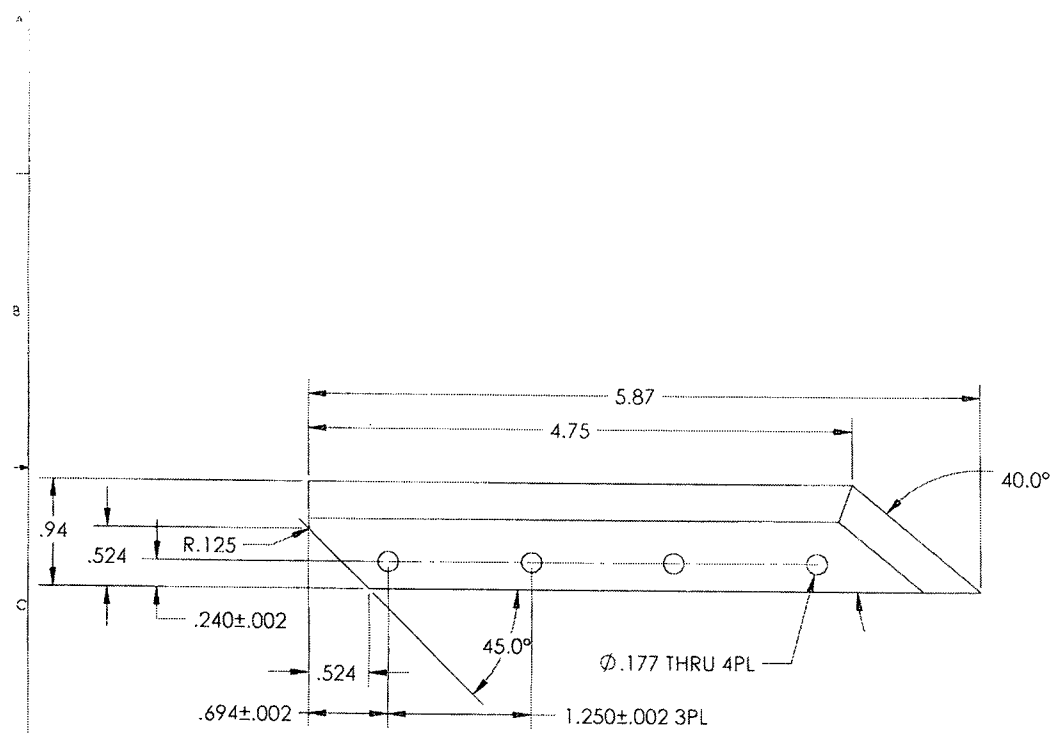
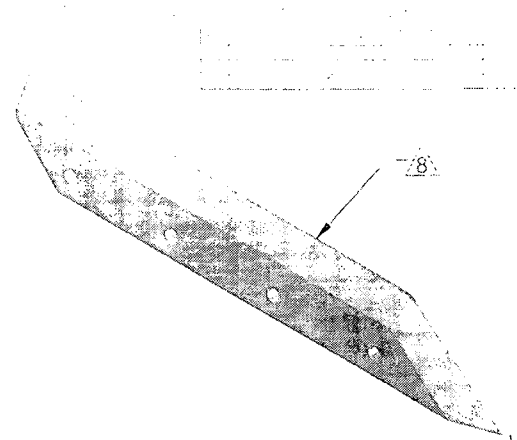
UPPER CUTTER ASSY



646.3315

<small> ORIGINAL DATE MODEL #81 DRAWN BY: T. H. H. H. S. H. H. H. DRAWING APPROVAL P. H. H. H. DATE CORRECTION </small>		APICAL INDUSTRIES 2608 TEMPLE MEKHITS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5200	
<small> UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE FRACTIONS DECIMALS ANGLES ± .5° </small>		SEE LIST CODE 646.3300	REV N/C
SCALE: NONE		SHEET 7 OF 8	

100125



646.3316

ORIGINAL DATE 10/01/01 DRAWN BY S. HUNT CHECKED BY P. BRAVO DRAWING APPROVAL P. BRAVO DATE 10/01/01		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 3 PLACES DECIMALS ±.01 1 PLACE DECIMALS ±.002 ANGLES ±.5°		SHEET CODE B 07420	DWG NO. 646.3300
SCALE NONE		REV N/C	
SHEET 8 OF 8			